

**Work Order ID 73635**

Thursday, September 08, 2011 7:45:14 AM

Page 1

Item ID: D3916-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly

Start Date: 9/9/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3916

A

0.00

0.00

100



Large Fab

Large Fab

**Memo**

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- \*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

SAP 11-09-21

105



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

**Memo**

SAP 11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 73635

Thursday, September 08, 2011 7:45:14 AM

Page 2

Item ID: D3916-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Rib Assembly					
Start Date: 9/9/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 9/14/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107  Large Fab	Weld per dwg A/R S.S. rod Batch: <u>117884</u>	0.00							
Large Fab	Memo 1- weld bushing as per dwg D3916 2- grind welds flush	0.00							
110  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
120  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							

*Pl 11.09.21* *(x6)*

*Sulash*

*Sulash*

*(x6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73635

Thursday, September 08, 2011 7:45:14 AM

Page 3

Item ID: D3916-041

Accept

Revision ID:

Item Name: Rib Assembly

Start Date: 9/9/2011 Start Qty: 6.00

Required Date: 9/14/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

*Cpl 11-09-21* *(x6)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/9/22* *(Signature)*

*MF*  
*11-09-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 08, 2011 7:45:10 AM

Page 1

Work Order ID: 73635

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 9/9/2011

Required Date: 9/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

215.0000

7

42



Bushing

Location

Loc Qty

Loc Code

WA

213

69202

13

72316

200

WA005

2

66489

2

M304TS0.750W.049

Purchased

No

100

f

288.2709

4.166

26.31158



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

187.5156839

117775

98.2133

118472

89.3023839

MAT034

1.8507

117337

1.8507

WA

98.90454

118184

98.90454

9/11/09/21

5  
37

SAD 11-09-21

26.3116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

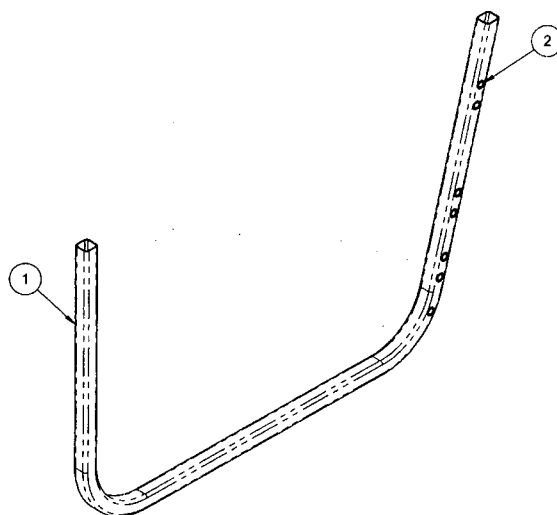
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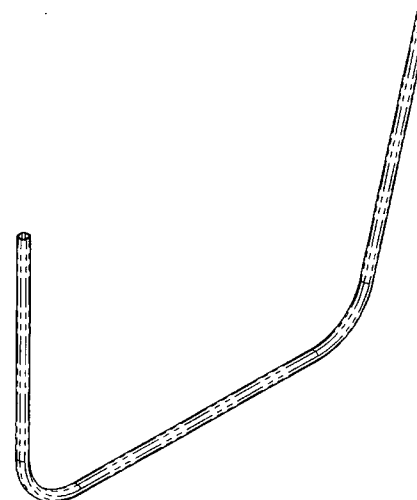
**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

# 73635

OK 10.12.21  
 UNDER REVIEW  
 ADDITIONAL HOLE + BUSHING  
 on D3916-041-1 RIBS.

**RELEASED**  
 2010-03-12  
 JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3916	SHEET 1 OF 4
APPROVED	JWP	TITLE	SCALE
DE APPR.	JWP	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

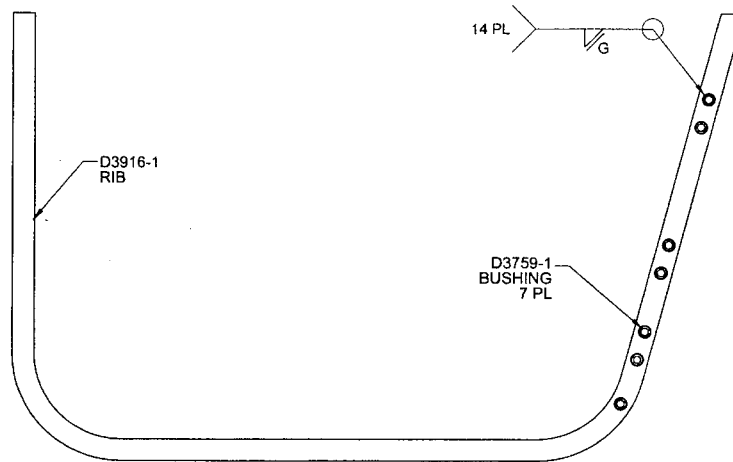
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3916-041 RIB ASSY**

# 73635

**RELEASED**  
2010-03-12  
NP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3916</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RIB ASSY, 350 BASKET</b>	NTS
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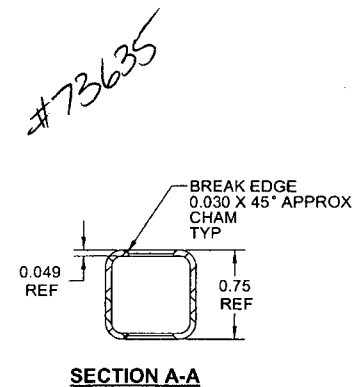
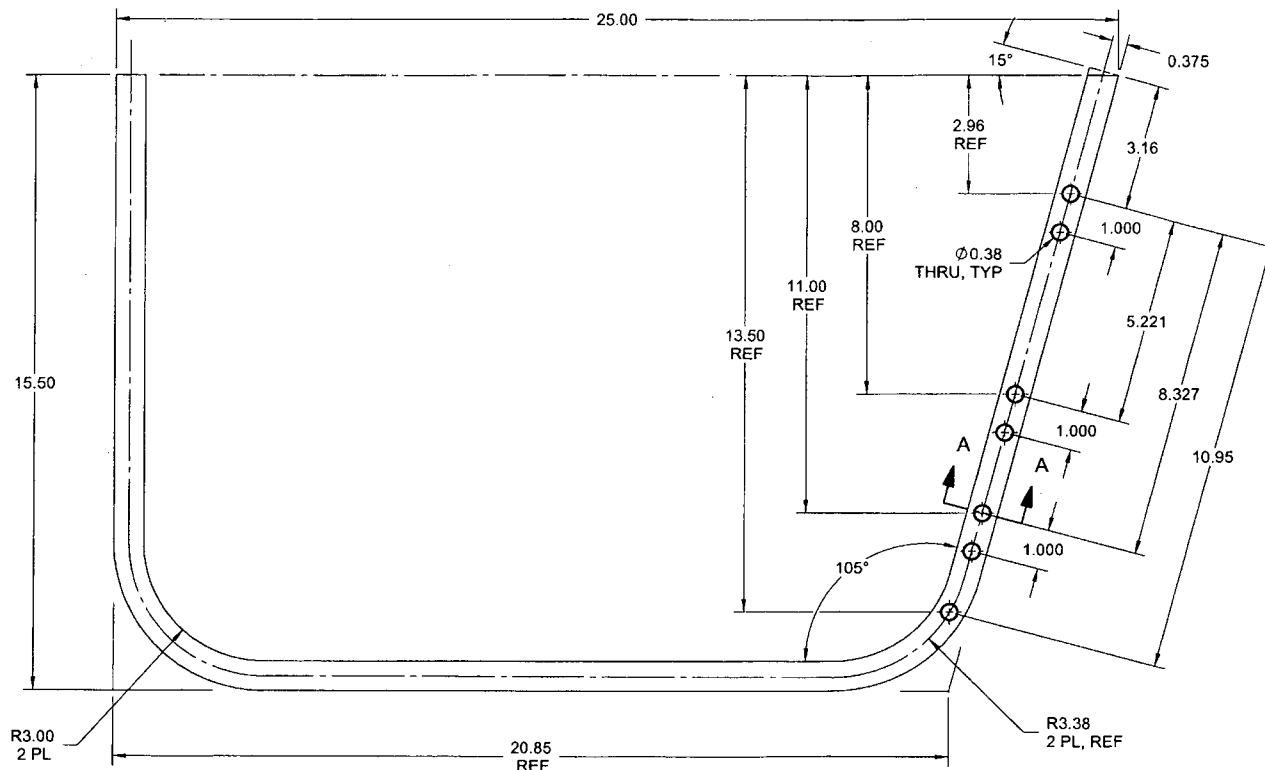
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



9 D3916-1 RIB

**RELEASED**  
2010-03-12  
JAP

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

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CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	EB	D3916	SHEET 3 OF 4
APPROVED	NW	TITLE	SCALE
DE APPR.	★	RIB ASSY, 350 BASKET	NTS
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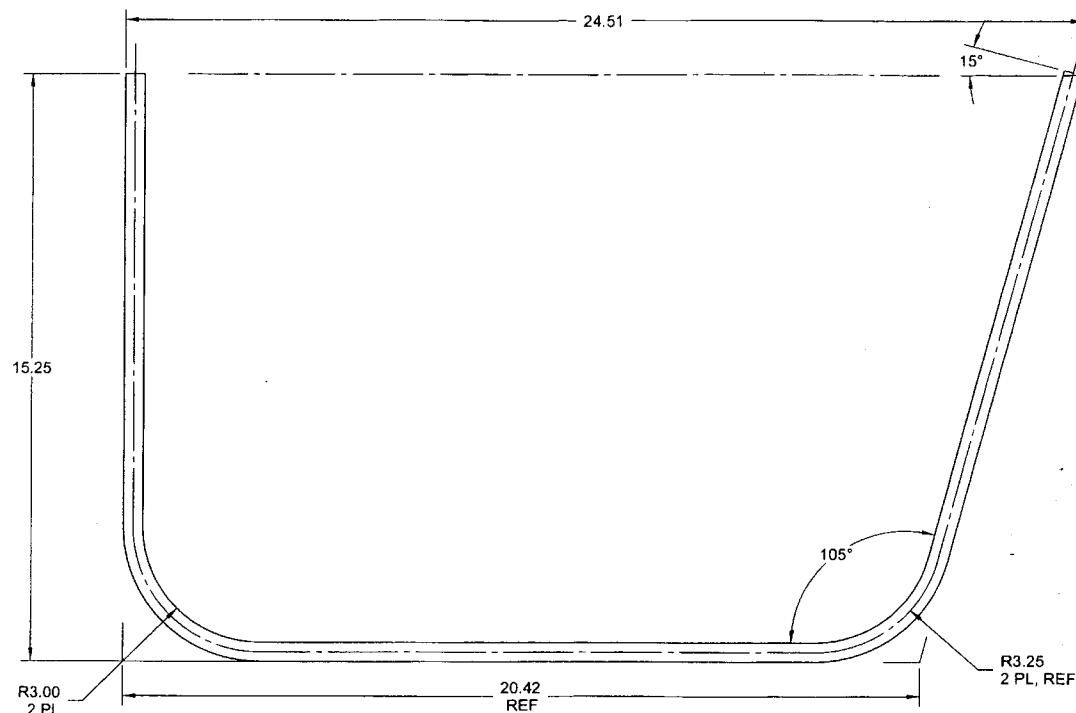
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



9 D3916-5 LIGHT RIB

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

**RELEASED**  
2010-03-12

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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